

Work Order ID 85621

June-12-12 8:51:30 AM

85621

Page 1

Item ID: D205-633-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step

Start Date: 12/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

N/A	Rev N/A
-----	---------

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP205-633-011 CHG001

DAS 16 12/06/15 JB

MLJ 12/07/12

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110

Packaging

Memo

0.00

Packaging

6

12/07/12 JB

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Memo

0.00

Quality Control

DAS 16 12/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

June-12-12 8:51:30 AM

Item ID: D205-633-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step

Start Date: 12/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-633-011

Location: 70

(Signature) 12/18/16

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/08/17
MLJ 12/08/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 85621

85621

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No			110	Each	244.0000	6	6			
<i>Spl</i> *AN4-14A*									**	122141 JB			
Bolt													

Location	Loc Qty	Loc Code
357	100	
121349	100	
ST357	144	
120187	13	
120769	1	
121068	17	
121444	100	
121708	13	

AN4-5A		Purchased	No			110	Each	923.0000	12	12			
<i>Spl</i> *AN4-5A*									**	JB			
Bolt													

Location	Loc Qty	Loc Code
ST355	923	
120562	923	

AN4-6A		Purchased	No			110	Each	1,385.0000	12	12			
<i>Spl</i> *AN4-6A*									**	JB 12/07/27			
Bolt													

Location	Loc Qty	Loc Code
355	93	
121631	93	
ST356	1292	
119017	792	
121243	500	

119017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85621

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

85621

D205-633-011

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

AN4-7A Purchased No

110 Each

120.0000

12

AN4-7A
Bolt

**

Location

Loc Qty

Loc Code

ST356

120

117514

20

120770

100

110 Each

65.0000

6

AN5-14A
AN5-14A
Bolt

**

Location

Loc Qty

Loc Code

ST

8

6071

8

ST338

7

119127

1

120360

6

ST339

50

121259

50

110 Each

26.0000

6

AN5-6A
AN5-6A
Bolt

**

Location

Loc Qty

Loc Code

ST337

26

117688

26

110 Each

30.0000

90

AN960JD416 NAS1149D0463J Purchased No
AN960JD416
Washer

**

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 85621

85621

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

AN960JD516 NAS1149D0563J Purchased No

110 Each

16.0000

4

24

AN960JD516

Washer

**

119546 JB



Location

Loc Qty

Loc Code

ST338

16

2612

16

D2021-101

Manufactured No

110 Each

18.0000

0

6

D2021-101

Eyebolt

**

JB



Location

Loc Qty

Loc Code

ST004

18

74599

18

D2022-101

Manufactured No

110 Each

52.0000

2

12

D2022-101

Spacer

**

74599
BRES JB



Location

Loc Qty

Loc Code

ST504

52

73307

1

79465

51

D2022-103

Manufactured No

110 Each

26.0000

2

12

D2022-103

Spacer

**

79465
2x 83996 JB

12/07/27



Location

Loc Qty

Loc Code

ST003

26

74531

26

10x 74531

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 85621

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

85621

D205-633-011

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2562-001

Manufactured No

110 Each

1.0000

D2562-001

Strut

6 ✓
** 5x 86382 JB B84733 (1X) ✓

Location

Loc Qty

Loc Code

ST

1

82564

1

D2563

Manufactured No

110 Each

0.0000

D2563

Step Weldment Assembly

D2565-101

Manufactured No

110 Each

8.0000

D2565-101

Strut

6 -
** 85622 L
6
** B85921 ✓

Location

Loc Qty

Loc Code

ST252

8

82563

8

D2565-103

Manufactured No

110 Each

10.0000

D2565-103

Strut

6 ✓
** B86383 (4x) ✓
JB

Location

Loc Qty

Loc Code

ST252

10

82562

10

D2565-105

Manufactured No

110 Each

12.0000

D2565-105

Strut

2x 82562
6 ✓
** 12/07/27
JB 4x B86384 ✓
2x 82561

Location

Loc Qty

Loc Code

ST252

12

73970

1

82561

11

June-12-12 8:51:34 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 85621

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

85621

D205-633-011

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2565-107

Manufactured No

110 Each

7.0000

D2565-107

Strut



**

6

B86385 sf

Location

Loc Qty

Loc Code

ST270

7

71474

1

82567

6

D2565-109

Manufactured No

110 Each

9.0000

D2565-109

Strut



**

6

B85922 (52)

(22)

B84737

B 86839 (42)

Location

Loc Qty

Loc Code

ST258

8

82569

8

ST270

1

64797

1

D2565-111

Manufactured No

110 Each

7.0000

D2565-111

Strut



**

6

85784 JB

Location

Loc Qty

Loc Code

ST270

7

82570

7

MS210421-4

Purchased No

110 Each

3,349.000

MS210421 4

Nut



**

48

JB 12/07/27

Location

Loc Qty

Loc Code

ST300

3349

119075

116

121011

232

121444

2701

121652

300

121444

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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June-12-12 8:51:34 AM

Work Order ID: 85621

85621

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

MS21042L5

Purchased

No

110

Each

1,381.000

2

12

**

MS21042L5

Nut

JB 12/07/27

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

881

108827

4

116105

5

116548

43

117611

18

119109

795

17651

8

2937

8

119/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21